



Dart Aerospace Ltd.
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K6A 1K7
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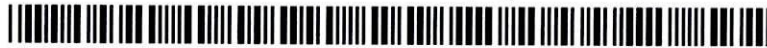
RBW6405G07331-3G
Job Sheet 172525



Part No: RBW6405G07331-3G

Job Qty: 4 ea

Part Name: Tail Rotor Scissors Short Coupling Removal Tool



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/20/18

Job Tracking No:

Due Date: 2/28/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G07331-3G REV: 2 DAS 45 2018-02-22
KIPP REV A 18.02.15 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

9-89

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	4 Ea		2/27/18	0.00	0.00	Start Up Small Fab-4		MLL
100	Small Fab	4 pcs		2/28/18	0.25	0.57	Small Fab-9		MLL
110	QC	4 pcs		2/28/18	0.00	0.00	QC5		JP
130	Packaging	4 pcs		2/28/18	0.00	0.00	Packaging3-2		18-04-20 GAB
140	QC21-FG	4 Ea		2/28/18	0.00	0.00	QC21		GA096 JB

Part Op 100 - Assemble

Descriptions: 130 - Identify and Stock

DAS
21
9-89

APR 23 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G07331-3G-1	Receiver	4 Ea (1 ea)	90-Start up Operation	5047518
RBW6405G07331-3G-3	Extractor	4 Ea (1 ea)	90-Start up Operation	5054599
AN316-4R 332	Hex Head Nuts	4 Ea (1 ea)	100-Small Fab	5041080
NAS1149D0463J 263	Washer	4 Ea (1 ea)	100-Small Fab	5045845

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	RBW6405G07331-3G-1	4	0	0
	RBW6405G07331-3G-3	4	0	0
100-Small Fab	AN316-4R	4	100	0
	NAS1149D0463J	4	2,845	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order: _____

Work Order: _____		DISPOSITION		T			
Part No. _____		Rework	☐				
NCR No. _____		Scrap	☐				
		Use-as-is	☐				
Suspected Unapproved							
Date : _____		Step #: _____					
Description Work Order Deviation							
Root Cause							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperatur	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Dam	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Inc	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐				
Misidentified	☐	Past Due	☐	OTHER : _____			

Inspector: _____
Revision: 2
Job No: 172525
Part: RBW6405607331 - 3G
Container No: S062769
AEROSPACE
DART
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 04/19/18

Engineering	☐
Quality	☐
Other	☐

RB (QSI042) Approval

Completed By

and / Supervisor
oval Verification

A Coordinator
pproval

ed Wrong
Dimensions
ler tolerance
rect
Missing
f

Drawing

Finish

Misread

Turning Sequence

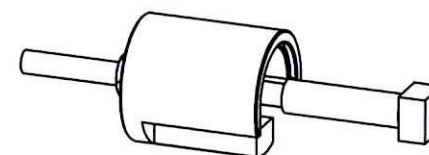
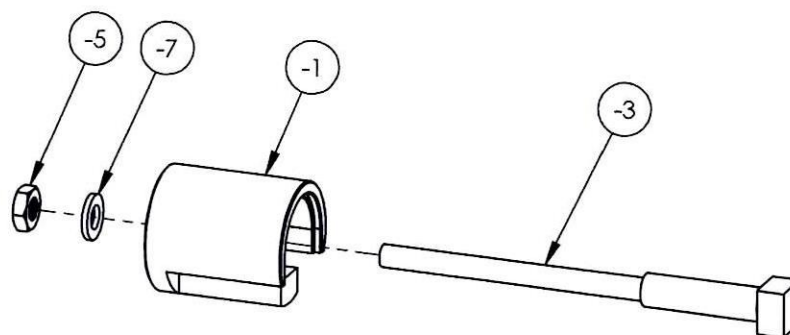
Unlabeled

Fit/Function

Misaligned/off center

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
A		CH'D ENGRAVE NOTE P/N -1.	5/29/2009	RJC	RW
2	15-0340	UPDATED TO NEW DRAFTING STANDARDS. -1 CH'D DIMS WAS Ø1.220 IS Ø1.38, WAS Ø.906 IS Ø1.004, WAS .294 IS .41, WAS 1.339 IS 1.34, WAS 1.578 IS 1.58, WAS .015 IS .02. ADDED SLOTS FOR TOOL FITTING.	10/27/2015	SM	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 172525 M.C.

18-02-20

NOTE:
REF. AGUSTA T/N: 3G6405G07331.

USED AS AN EXTRACTOR DURING
THE REMOVAL PROCEDURES DURING
THE DISASSEMBLY OF THE TWO HALF SCISSORS
P/N 3G6430A00331.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RECEIVER	6061		2
			-3	1	EXTRACTOR	4140/4142		3
		B/O	-5	1	NUT	STEEL	1/4-28 (SPENCER AIRCRAFT #AN316-4R)	1
		B/O	-7	1	WASHER	STEEL	Ø1/4 (AIRCRAFT SPRUCE #AN960-416)	1

DART AEROSPACE	
TITLE T/R SCISSORS SHORT COUPLING REMOVAL TOOL	
DWG NO. RBW6405G07331-3G	REV 2
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D. Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL AGUSTA
SCALE 1:2	DATE 2/3/2009
SHEET 1 OF 3	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																													
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																																																										
Description Work Order Deviation				Disposition				Completed By																																																									
WORK ORDER NON-CONFORMANCE / UPDATE								Lead hand / Supervisor Approval Verification																																																									
								QC / QA Coordinator Approval																																																									
Root Cause		FAULT CATEGORY																																																															
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐	Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐	Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐																																																																